

Date: Monday, 5/15/2006 11:16:24 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET, GAS SPRING STUD
Job Number : 27126
Estimate Number : 10183
P.O. Number : N/A Part Number : D2154
This Issue : 5/15/2006 S.O. No. : N/A Drawing Number : D2154 REV. C
Prsht Rev. : NC Project Number : N/A
First Issue : 5/15/2006 Type : PURCHASED PARTS Drawing Revision : C
Previous Run : 26026 Material : N/A
Written By : SRE COMMENT BELOW Due Date : 6/4/2006 Qty: 50 Um: Each
Checked & Approved By : 06-05-15
Comment : Est: C 03.06.08 Reformat; Remove Tumble KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1263
Email or Ship DXF file to vendor
Laser Cut flat pattern per Dwg D2154
Material release note is required

C206105116 (50)

2.0 D2154F Bracket, Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
BRACKET, GAS SPRING STUD

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

06/15/25 (54)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-05-25 54

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

M.F. 06-05-30 (54)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET, GAS SPRING STUD

Job Number: 27126

Part Number: D2154

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2154 Rev: C

SP 06/06/01

54

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/06/02 (54)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

FC 06 06 02 (54)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

h 06/06/05 (29)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5726

06/06/05 (29)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

250
06/06/05

Job Completion



U 06-08-05

G GERDAU AMERISTEEL

CAMBRIDGE STEEL MILL

160 ORION PLACE

CAMBRIDGE ON N1T 1R9 CAN

(519) 748-2488

SHIP TO
VEDDER TRANSPORT
C/O WILKINSON STEEL AND METALS
588 RIVERSIDE ROAD
ABBOTSFORD, BC

INVOICE TO
WILKINSON STEEL & METALS VAN
PREMETALCO INC
888 SOUTHEAST MARINE DR
VANCOUVER, BC V5X 2V3

SHIP DATE
01/12/06
CUST. ACCOUNT NO
60073699

MADE IN CANADA

Chemical and Physical Test Report

N-037186

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SHAPE + SIZE		GRADE		SPECIFICATION		SALES ORDER													CUST P.O. NUMBER													
AZ X 2 X 1/4		44W		CSA-G40 21-300W-9844WV, ASTM A36/A36M-04		5113567-03													PS1121MV001													
HEAT ID.		C		Mn	P	S	Si	Cu	Ni	Cr	Mo	V	Nb	B	Sn	Al	Zr	C	Eqv													
NS45178		18		59	009	034	15	25	12	14	060	001	000	0000	017	001	002	306														
Mechanical Test		Yield		50258		PSL 346.52 MPa		Tensile		74435		PSL 513.21 MPa		%EL: 27.07%, 27.0700MM		Red R 26.7 : 1																
Yield		49565		PSL 342.43 MPa		Tensile		74737		PSL 515.29 MPa		%EL: 27.07%, 27.0700MM		Red R 26.7 : 1																		
NS45180		15		63	011	034	18	27	09	16	043	004	001	0000	019	001	002	325														
Mechanical Test		Yield		48109		PSL 331.7 MPa		Tensile		70847		PSL 488.47 MPa		%EL: 28.50%, 28.5200MM		Red R 26.7 : 1																
Yield		40088		PSL 331.56 MPa		Tensile		71075		PSL 490.04 MPa		%EL: 28.07%, 28.0700MM		Red R 26.7 : 1																		
SHAPE + SIZE		GRADE		SPECIFICATION		SALES ORDER													CUST P.O. NUMBER													
AZ X 2 X 1/4		44W		CSA-G40 21-300W-9844WV, ASTM A36/A36M-04		5113567-03													PS1121MV001													
HEAT ID.		C		Mn	P	S	Si	Cu	Ni	Cr	Mo	V	Nb	B	Sn	Al	Zr	C	Eqv													
NS45179		18		66	010	024	18	21	11	11	041	003	000	0001	051	001	002	342														
Mechanical Test		Yield		50587		PSL 348.65 MPa		Tensile		73436		PSL 506.32 MPa		%EL: 27.07%, 27.0700MM		Red R 26.7 : 1																
Yield		50554		PSL 348.56 MPa		Tensile		73511		PSL 507.53 MPa		%EL: 27.07%, 27.0700MM		Red R 26.7 : 1																		
NS45179		18		66	010	024	18	21	11	11	041	003	000	0001	051	001	002	342														
Mechanical Test		Yield		50587		PSL 348.65 MPa		Tensile		73436		PSL 506.32 MPa		%EL: 27.07%, 27.0700MM		Red R 26.7 : 1																
Yield		50554		PSL 348.56 MPa		Tensile		73511		PSL 507.53 MPa		%EL: 27.07%, 27.0700MM		Red R 26.7 : 1																		

This material, including the tickets, was produced and manufactured in Canada.
A.L. Turner
Quality Assurance Manager
Mill Group

THE ABOVE FIGURES ARE CERTIFIED EXTRACTS FROM THE ORIGINAL CHEMICAL AND PHYSICAL TEST RECORDS
AS CONTAINED IN THE PERMANENT RECORDS OF COMPANY

Cambridge Steel Mill
Mgt. Metallurgy Svcs.

